

Date: Thursday, 26/02/2009 11:40:48 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: RIB	
Job Number	: 46083			Part Number	: D22217	
Estimate Number	: 13675			Drawing Number	: D2221 REV H (PG.5)	
P.O. Number	:			Project Number	: N/A	
This Issue	: 26/02/2009	S.O. No.	:	Drawing Revision	: H	
Prsht Rev.	: NC			Material	:	
First Issue	: //	Type	: LARGE FAB ASSY			
Previous Run	: 45781			Due Date	: 04/03/2009	
Written By	:			Qty:	4	
Checked & Approved By	: JUL 09 - 02-26			Um:	Each	
Comment	: Est Rev:A New Issue 08-12-02 DD verified by:EC					

Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
		
Comment: Qty.: 4.8344 f(s)/Unit Total : 9.6688 f(s) 304 SQ Tube .75x.75x.065W <i>19.3378 ✓</i> batch: <i>M10839 → 9.6688</i> <i>by 09/03/04</i>		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1 1- Cut as per dwg D2221 <i>by</i> 2- Deburr and remove identification markings on tube <i>by</i> <i>by 09/03/04 (4)</i>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP <i>S 09/03/04 (4)</i>		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>BASKET CELL</i> <i>by 09/03/04 (4)</i>		
5.0	QC21	FINAL INSPECTION/W/O RELEASE
		
Comment: FINAL INSPECTION/W/O RELEASE <i>09/03/05 (4)</i>		
Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

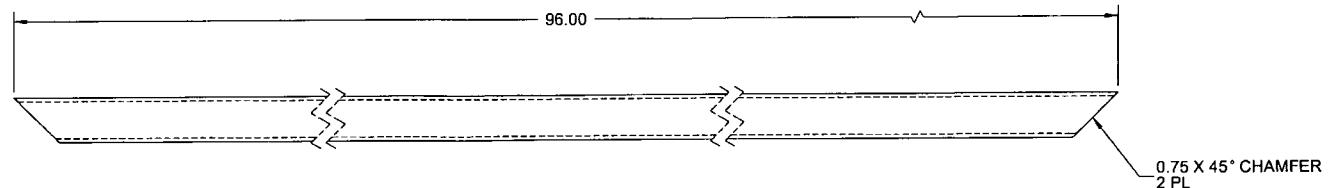
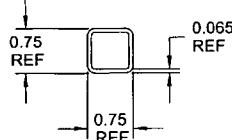
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

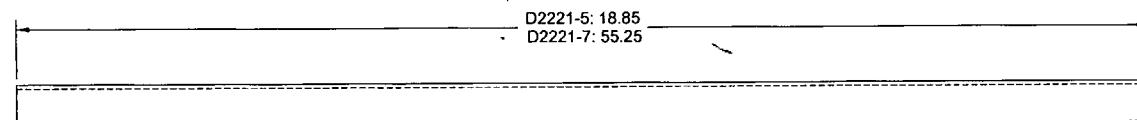
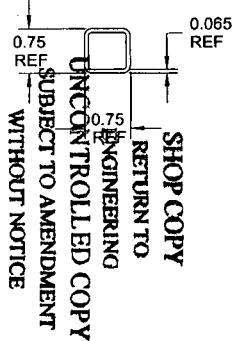
D

D

**D2221-1 RIB**

C

C

**D2221-5/7 RIB**

B

B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

8 7 6 5 4 3 2 1

DESIGN	B/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	
MFG. APPR.		REV. H	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
08/11/18 JMB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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